

shp 18/09

Work Order ID 107037

107037

Page 1

September-16-13 11:20:21 AM

Item ID: D4636-5 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket
 Start Date: 9/16/13 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 9/18/13 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: MJS Date: 13-09-16 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4636	C

100	FLOW WATER JET	0.00				21	0		<u>Ac</u> 13.09.18
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
<u>60061-040</u>	Dwg Rev: <u>C</u>								
	Prog Rev: <u>C</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				21	0		<u>Ac</u> 13.09.18
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00				21			
120									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89

13 9 18

Work Order ID 107037

107037

Page 2

September-16-13 11:20:21 AM

Item ID: D4636-5 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket
 Start Date: 9/16/13 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 9/18/13 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab Small Fab	Counter sink Memo 1- C'SINK HOLES AS PER DWG	0.00 0.00				21			13/09/13
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		DAS 27 9-89 B918		21			
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				21		7613719	

Work Order ID 107037

September-16-13 11:20:21 AM

107037

Page 3

Item ID: D4636-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 9/16/13

Start Qty: 20.00

20

Cust Item ID:

Required Date: 9/18/13

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

21XØ m/f 13/09/19

170

Black Sandtex(Ref:4.3.5.7) per QS1005 4.3

0.00

170

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

11:30
320°F
12:00

21XØ m/f 13/09/19

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

21XØ m/f 13/09/19

m 117338

Picklist Print

September-16-13 11:20:20 AM

Page 1

Work Order ID: 107037

Parent Item: D4636-5

Parent Item Name: Bracket

Start Date: 9/16/13

Required Date: 9/18/13

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 12.04.30 NEW ISSUE DD VERF:EC
DWG REV.C DD VERF:JLM

IPP REV:C 13.07.17 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040 6061-T6 .040 Sheet		Purchased	No			100	sf	264.5670	0.01	0.2105263			

13.09.18

Location

Loc Qty

Loc Code

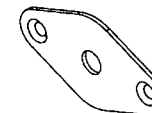
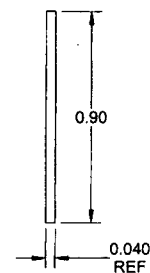
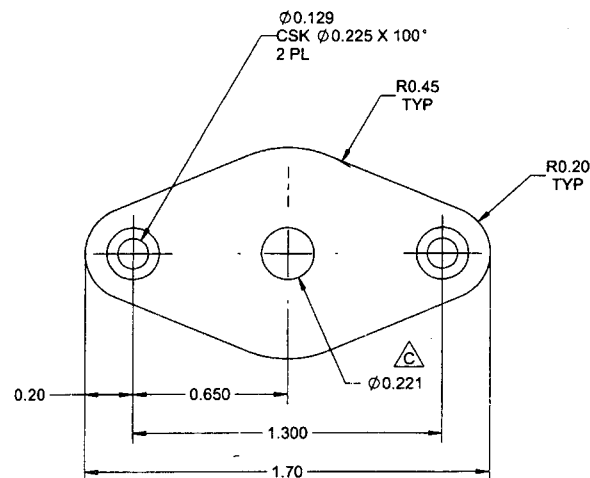
MAT021

264.567

m126350

264.567

126350 → .211



D4636-5 BRACKET

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.00 lbs

107037 MLW
13-09-16

RELEASED
2013-07-15

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4636	REV. C
MFG. APPR.	<i>[Signature]</i>		SHEET 4 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET ASSEMBLY	NTS
DATE	13.06.18	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	